

# Work Order ID 54518

December 10, 2009 3:23:11 PM



SHIP TUESDAY Page 1

Item ID: D105-674-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube

Stop



Start Date: 12/10/2009 Start Qty: 1.00

Required Date: 12/10/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-12-10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2966	Rev A2

310 0.00



DC

Memo

Document Control

Photocopy bluefile & type labels per PPP D105-674-011 CHG002

N/P 54625

320

Pick Kit



Packaging

Memo

Packaging

PULL FROM STOCK:

D105-674-011WG

B 44847

1344849

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D105-674-011 WG	CHG	CHG002
DESC	Skidtube	STC	SR00910SE
LOT	B44847	STC	
MODEL	BO 105	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D105-674-011 WG	CHG	CHG002
DESC	Skidtube	STC	SR00910SE
LOT	B44849	STC	
MODEL	BO 105	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54518

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Page 2

Item ID: D105-674-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube

Start Date: 12/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

330 305

0.00

=> 11 09/12/14

(X2)

Q

HandFinish

0.00

Hand Finishing

Memo

DISASSEMBLE PARTS AND HARDWARE FROM SKID  
PUT ASIDE TO REINSTALL

SCUFF ENTIRE TUBE LIGHTLY

340 306

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo 11/12/588.

REPOWDER COAT GREY SANDTEX

B

OVEN TEMP: 320°

START 11:00

FINISH 11:30

0.00

BL 09-12-14

Q2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54518

December 10, 2009 3:23:11 PM



Page 3

Item ID: D105-674-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube

Stop



Start Date: 12/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

345

QC3- Inspect Part Finish

0.00

27 80912/14



QC

Memo

0.00

Quality Control



350

0.00



Small Fab

Memo

0.00

Small Fab

RE-ASSEMBLE SKID PER DRAWING USING THE ORIGINAL PARTS AND  
HARDWARE  
REPLACE ANY HARDWARE IF NECESSARY

29166 rev A2 27 08/12/14 (X2) 9

→ Re apply wing work to per AS700 S  
BE M112263  
QC4- 100% Inspect kits for completeness

360

0.00



QC

Memo

0.00

Quality Control

27 80912/14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 54518

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Page 4

Item ID: D105-674-011

Revision ID:

Item Name: Skidtube

Start Date: 12/10/2009 Start Qty: 1.00

Required Date: 12/10/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \_\_\_\_\_  
Stop \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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370



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

## Memo

STOCK AND ID UNDER NEW BATCH NUMBER  
NEW LABELS AND PAPERWORK ARE REQUIRED.

*pull  
on w/o.  
#54625.  
D105-674-011B.  
- Forget to add.  
Grey on  
part number  
mf  
09-12-15*

*QC21. 09.12.15*

*mf 09-12-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Page 1

December 10, 2009 3:23:10 PM

Work Order ID: 54518



Parent Item: D105-674-011



Parent Item Name: Skidtube

Start Date: 12/10/2009

Required Date: 12/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D105-674-011WG		Manufactured	No				Each	2.0000	1.0000			



Skidtube, White Gloss

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

44847

1

44849

1

MF 09-12-15  
MF 09-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED  
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

#54518 A2

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.6.4) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART  
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7) A1

# 01.01.29  
CP 01.01.30

A2	02.10.30	ADD D3176-1/-3	[Signature] CP
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	[Signature] CP

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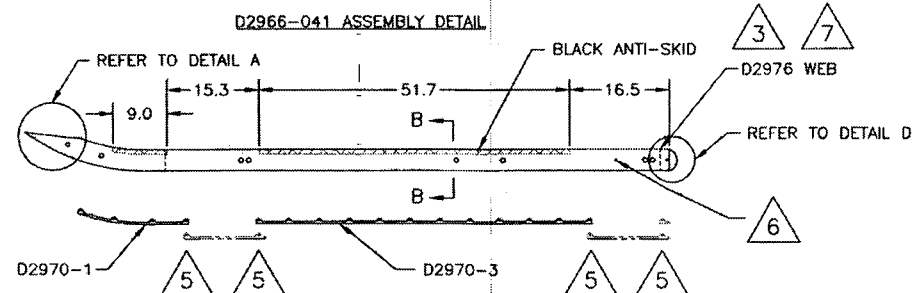
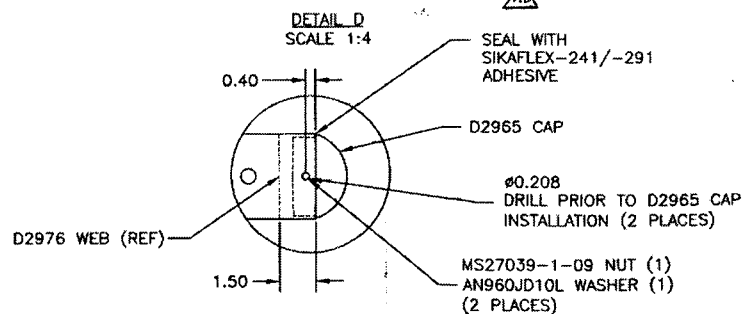
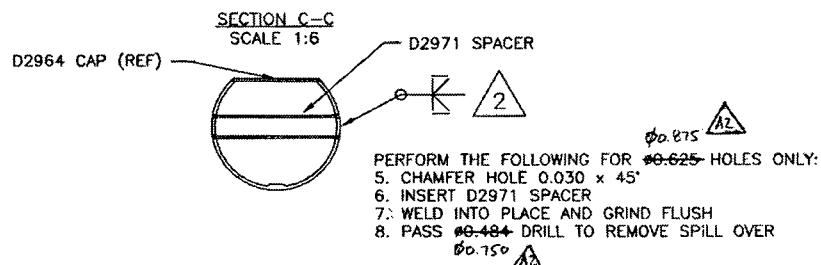
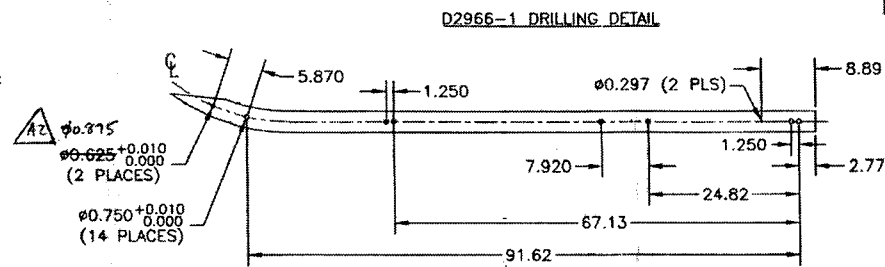
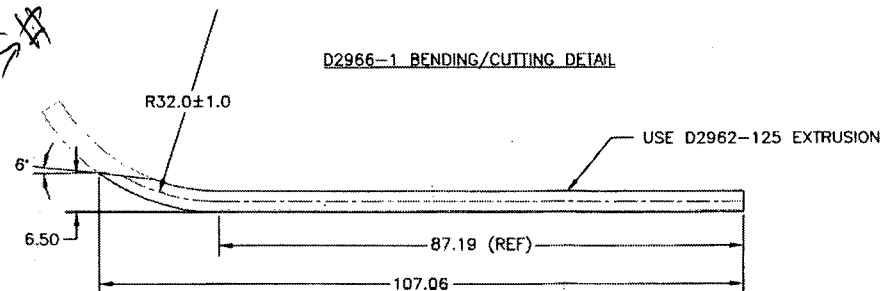
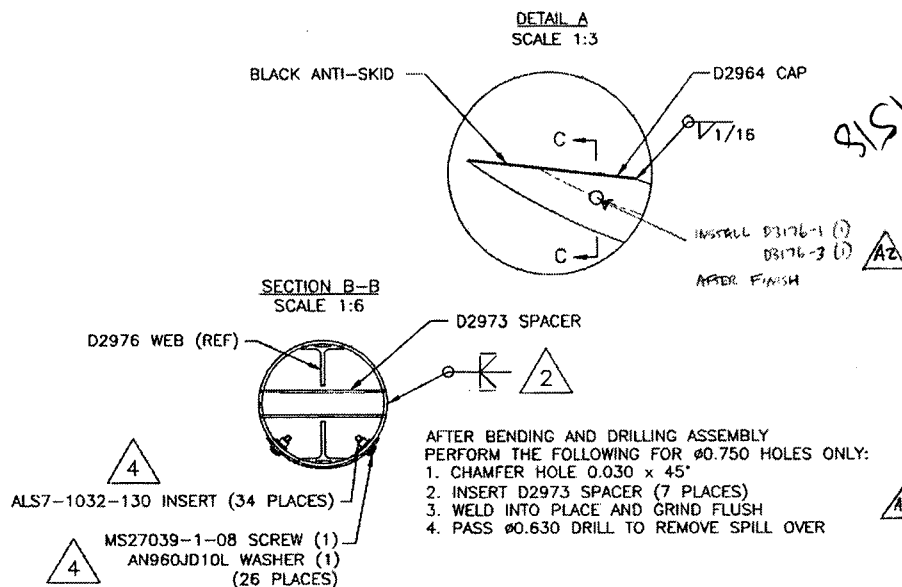
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED A	APPROVED A	DRAWING NO. D2966	SHEET 2 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY		SCALE 1:20	

RELEASED  
00-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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